

Date: Tuesday, 16/09/2008 3:28:46 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 42041		
Estimate Number	: 13107		
P.O. Number	:	Part Number	: D3719041
This Issue	: 16/09/2008 S.O. No. :	Drawing Number	: D3719 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 36446	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 08-9-16</u>		
Comment	: Est Rev :A New Issue 07-12-19 EC verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.5933 sf(s)/Unit Total: 5.9325 sf(s)

304/316 .060 Sheet

Batch: 108724 B 8-9-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3719

Dwg Rev: AProg Rev: AB 8-9-17

(14)

2-Deburr if necessary

B 8-9-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-9-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5081041/18

(X40)

5.0	D30093	Cup
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

CUP

Batch: 941176B 8-9-23 (X56)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:46 PM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42041

Part Number: D3719041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3719

w/ 316 LHS: M107051

X14

2-Weld hard facing as per Dwg D3719

A/R 2059B Hard Coat rod

Batch: M109213

EL 8-9-27

7.0

QC9

VISUAL WELDING INSPECTION



08-09-25



X14 (PL)

Comment: VISUAL WELDING INSPECTION

PD 08-09-25

8.0

POWDER COATING

POWDER COATING



M106442



14X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:15

OVEN TEMPERATURE:

320 OF

FINISH TIME:

8:45

M-1 08/09/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-26

X14

10.0

PACKAGING 1

PACKAGING RESOURCE #1



X14

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 500

8/9/26

SR

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/25	#7-1	inspect QCS 808/08/25 (X14) Permit change		08/09/25			08/09/25	

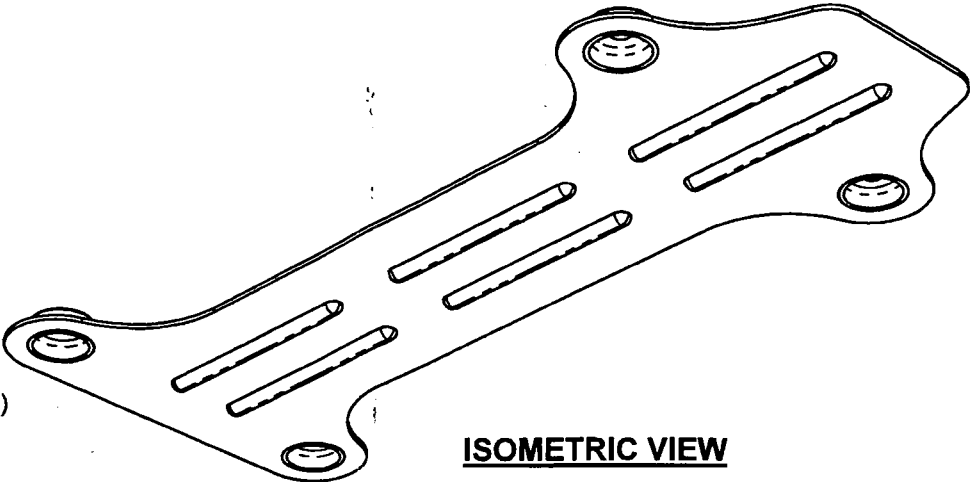
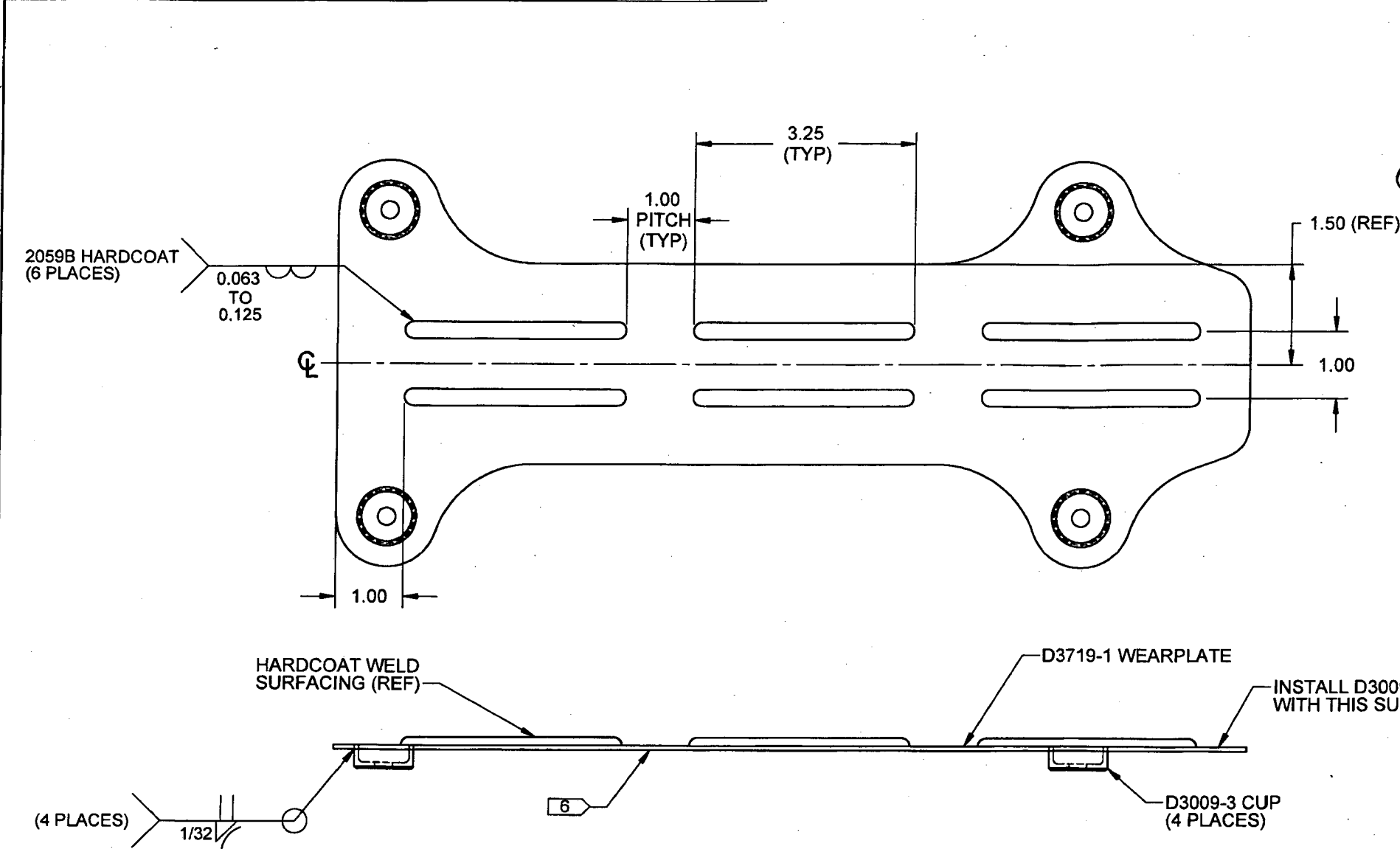
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



ISOMETRIC VIEW

D3719-041 WEARPLATE

RELEASED
07-01-07 JML

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004

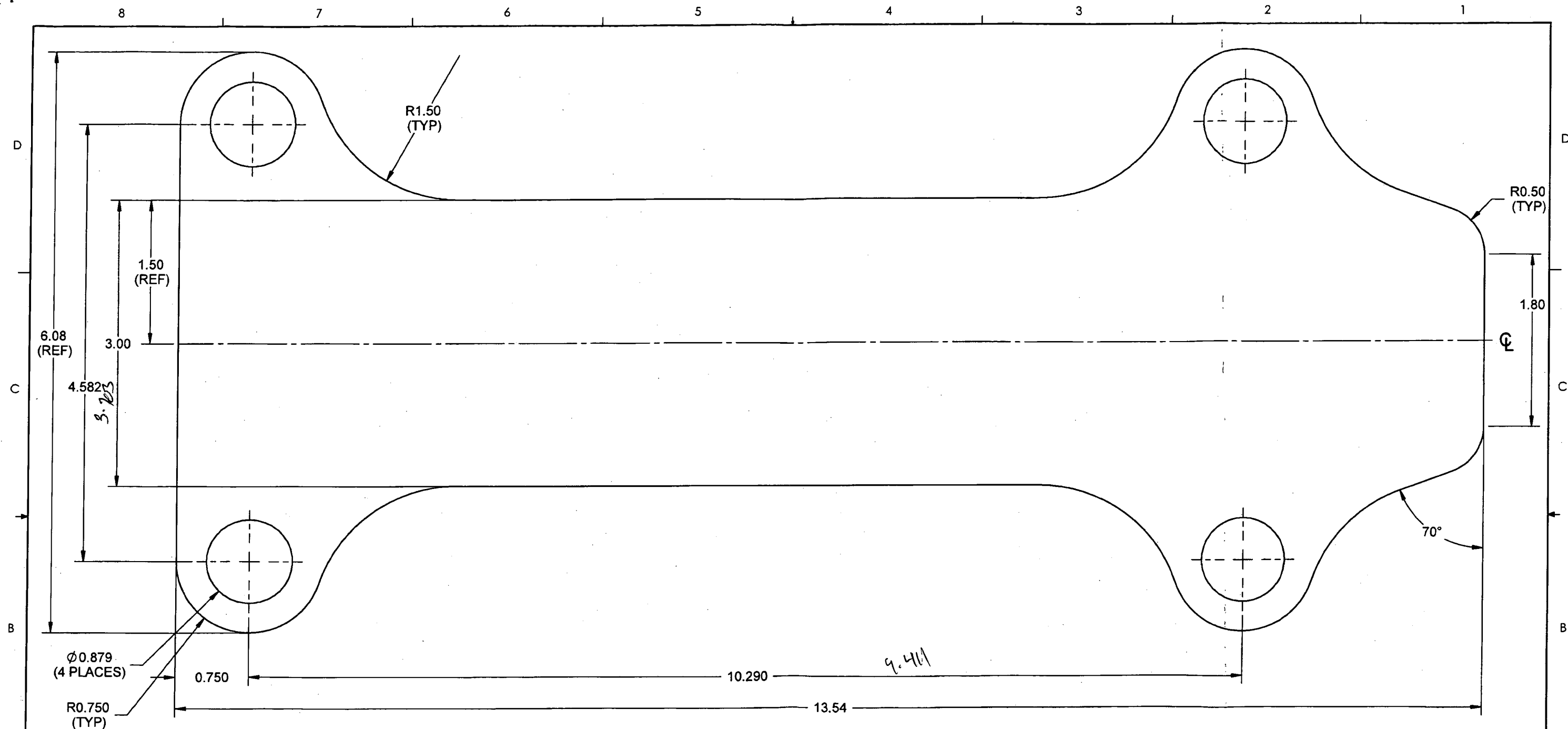
A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3719
TITLE
WEARPLATE

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WORK ORDER
NO. 42041



D3719-1 WEARPLATE

RELEASED
09.01.07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. RETURN TO
MFG. APPR.		D3719	SHEET 2 OF 2 ENGINEERING
APPROVED		TITLE	UNSCALE ROLLED COPY
DE APPR.		WEARPLATE	SUBJECT TO AMENDMENT
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NO. 10041

